

**TIG 308L**



TIG 308 L is used to weld 18/8 stainless steels including 301, 302, 303, nitrogen bearing 304LN and similar. Service temperatures are typically -100°C to about 400°C, Applications can be found in the brewery, food, architectural and general fabrication industries.

**CLASSIFICATIONS**

AWS	A5.9	ER308L
BS EN	12072	19 9 L
DIN	8556	SG X2CrNi 19 9 (1.4316)

**CHEMICAL ANALYSIS**

% Carbon	0.03 max.	% Phosphorus	0.03 max.
% Manganese	1.00 - 2.50	% Chromium	19.5 - 22.0
% Silicon	0.30 - 0.65	% Nickel	9.0 - 11.0
% Sulphur	0.03 max.	% Ferrite	10.00

**TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL**

	<b>TIG</b>
Tensile Strength	605 MPa
0.2% Proof Stress	465 MPa
Elongation on 4d	35%
Impact Energy -20°C	80J

**Microstructure**

Austenite with a controlled level of ferrite, normally in the range 2-10FN.

**PACKING DATA**

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-560	5
2.40	100	12	030-561	5

Suggested gas for welding : Argon (TIG)

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